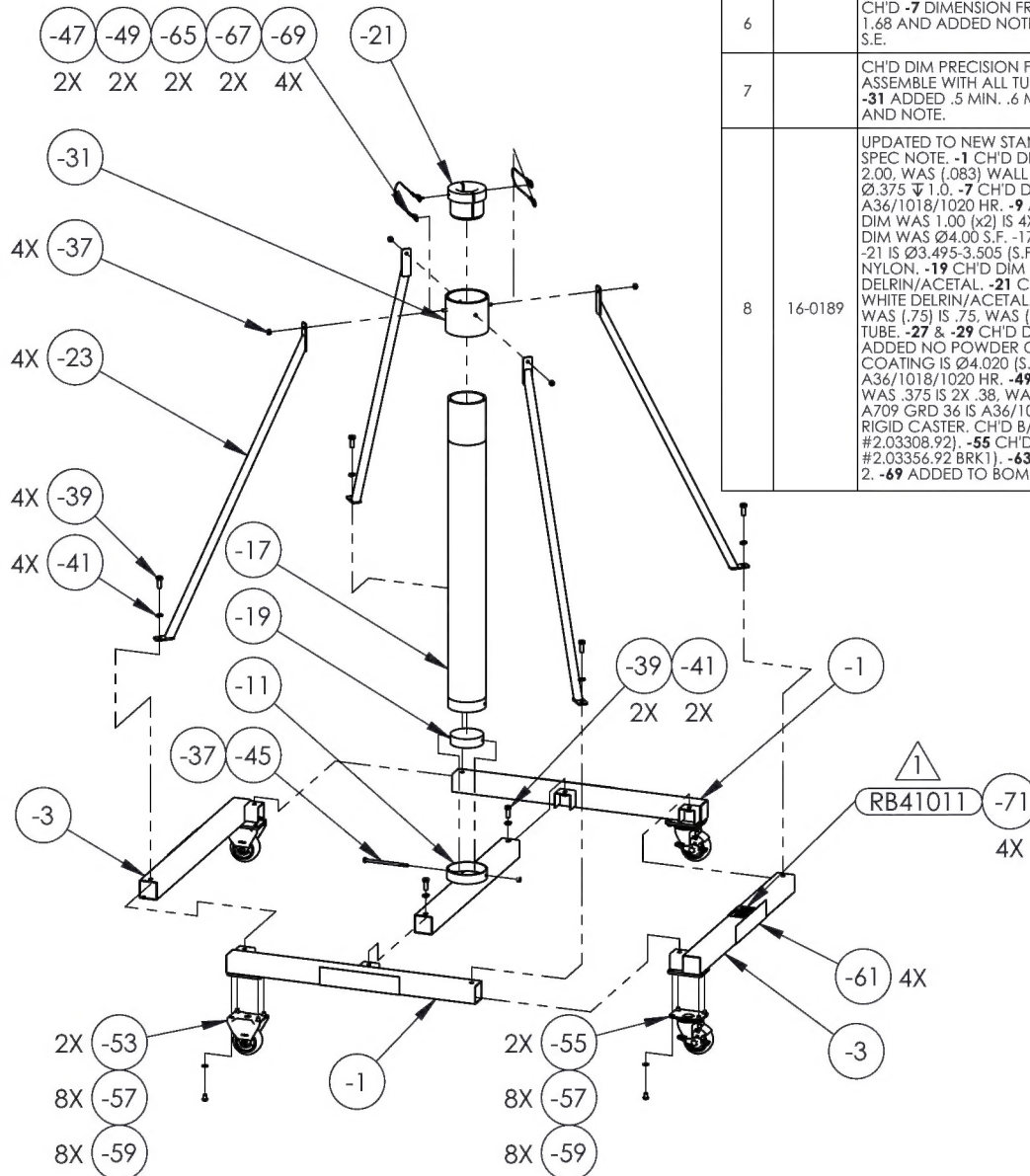


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADJUSTED -17 TO ALLOW FOR OVERSIZE PLASTIC TUBE CONDITIONS.	11/24/2008	WP	RW
2		ADDED WHEEL PADS, CASTERS & HARDWARE & CLEARANCE HOLES PER CUSTOMER REQUEST. SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES. ALSO CHANGED TUBE END CAPS FROM PLASTIC OUTWATER #T64-U-2-BLK TO WELDED METAL.	3/2/2009	WP	RW
3		CH'D P/N -7 OVERALL LENGTH FROM 4.872 & DIM. TO FIRST FOLD LINE FROM 1.606 PER W.P.	10/27/2009	WP	
4		CH'D LENGTH -33 FROM 4.250 TO 3.750 PER D.W.	1/15/2010	RJC	RW
5		CH'D Ø.405 HOLE TO A SLOT ON BOTH ENDS -13 PER G.E. MOVED ALL PARTS TO SEPARATE PAGES.	3/3/2011	RJC	GE
5A		ADDED NOTES 1 & 2, CH'D ALL HARDWARE TO S.S. & ADDED P/N'S PER R.W.	9/6/2011	RJC	RW
6		CH'D -7 DIMENSION FROM 1.825 +.000-.020 TO 1.825 +.000-.025. CH'D 1.500 TO 1.50. CH'D 1.680 TO 1.68 AND ADDED NOTE 1 PER S.E. CH'D TOLERANCE ON ALL SHEETS FROM .XXX ± .005 & .XX ± .01 PER S.E.	6/4/2012	RJC	SE
7		CH'D DIM PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. -1, -3, & -23 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM. -5a & -5b DELETED NOTE WAS SEAM ON BOTTOM. -31 ADDED .5 MIN. .6 MAX. DIM. -35 CH'D FROM STEEL TO STAINLESS & ADDED DWG TO MODIFY AND NOTE.	8/12/2013	RJC	DW
8	16-0189	UPDATED TO NEW STANDARDS. ADDED ENGRAVE NOTE FOR PLACARD. REMOVED GENERIC PLATE SPEC NOTE. -1 CH'D DIM WAS 14.00 IS (14.00). -5a & -5b CH'D DIMS WAS (2.00) IS 2.00. WAS (2.00) IS 2.00. WAS (.083) WALL IS .08. WAS Ø.405 ONE WALL IS Ø.405 ± 1.0. WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ± 1.0. -7 CH'D DIMS WAS 1.68 IS 2X 1.68. WAS .075 IS .08. CH'D MAT'L WAS A709 GRADE 36 IS A36/1018/1020 HR. -9 ADDED B/O REF #93560A160. -11 CH'D DIM WAS 24.50 IS (24.50). -13 CH'D DIM WAS 1.00 (x2) IS 4X 1.00. WAS (2.00) IS 2.00. WAS (2.00) IS 2.00. WAS (.083) WALL IS .08. -15 CH'D DIM WAS Ø4.00 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17). -17 CH'D DIM WAS Ø3.500 S.F. -21 IS Ø3.495-3.505 (S.F. -21). ADDED DIMS Ø3.50, Ø4.00. CH'D MAT'L FROM NATURAL TO NATURAL. NYLON. -19 CH'D DIM WAS Ø3.500 S.F. -17 IS Ø3.470 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL. -21 CH'D DIM WAS Ø3.490 IS Ø3.480-3.490 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL. -23 CH'D DIM WAS (37.34) IS (37.37). ADDED WELD SYMBOLS. -25 CH'D DIMS WAS (.75) IS .75. WAS (.75) IS .75. WAS (.083) WALL IS .08. CH'D MAT'L WAS 1018 SQ. TUBE IS STEEL TUBE. -27 & -29 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -31 ADDED NO POWDER COAT ON THREADS NOTE. -33 CH'D DIM WAS Ø4.000 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17). -43 CH'D DIM WAS 1.6ga. (.060) IS .06. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -49 CH'D B/O REF WAS #30345T11 IS #CL-2-C. -51 CH'D DIMS WAS (.25) IS .25. WAS .375 IS 2X .38. WAS 3.000 IS 2X 3.000. WAS .50 IS 2X .50. WAS 1.750 IS 2X 1.750. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR. -53 CH'D DESCRIPTION WAS 3 in. RIGID CASTER W/ BRAKE IS 3 in. RIGID CASTER. CH'D B/O REF WAS APPLIED INDUSTRIAL #1F9303B25002100 IS (GALIFCO, COLSON #2.03308.92). -55 CH'D B/O REF WAS APPLIED INDUSTRIAL #2F9803B25002100 IS (GALIFCO, COLSON #2.03356.92 BRK1). -63 REPLACED W/ RB41011. -65 ADDED TO BOM QTY 2. -67 ADDED TO BOM QTY 2. -69 ADDED TO BOM QTY 4. -71 ADDED TO BOM QTY 4.	10/25/2016	DPD	JAG

NOTE:

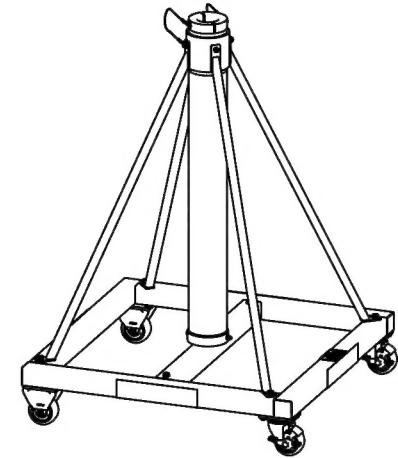
- 1 ENGRAVE T/N, S/N, "MADE IN USA",
SWL 250 LBS.

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657	REV 8
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 ANGLES ± 1° SURFACES = 125°	
SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	QA APPR: LINDSAY
CHECKED: CLOUGH	APPROVED: GILBERT
OPPS APPR: ANDERSON	USED ON MODEL FIRE SCOUT
SCALE 1:20	DATE 10/3/2008
SHEET 1 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	REMOVED GENERIC PLATE SPEC NOTE. -9 ADDED B/O REF #93560A160. -49 CH'D B/O REF WAS #30345T11 IS #CL-2-C. -53 CH'D DESCRIPTION WAS 3 in. RIGID CASTER W/ BRAKE IS 3 in. RIGID CASTER. CH'D B/O REF WAS APPLIED INDUSTRIAL #1F9303B25002100 IS (GALIFCO, COLSON #2.03308.92). -55 CH'D B/O REF WAS APPLIED INDUSTRIAL #2F9803B25002100 IS (GALIFCO, COLSON #2.03356.92 BRK1). -63 REPLACED W/ RB41011. -65 ADDED TO BOM QTY 2. -67 ADDED TO BOM QTY 2. -69 ADDED TO BOM QTY 4. -71 ADDED TO BOM QTY 4.	10/25/2016	DPD	JAG

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-1	2	BASE SIDE WELDMENT			3
			X			-3	2	BASE END WELDMENT			4
				1		-5a		BASE SIDE TUBE	STEEL TUBE Δ		5
				1		-5b		BASE TUBE	STEEL TUBE Δ		6
				1	2	-7		CLIP	A36/1018/1020 HR		7
				1	2	B/O	-9	WELD NUTS	STEEL	3/8-16 (MCMaster-CARR #93560A160)	3 & 4
	X					-11	1	BASE CENTER TUBE WELDMENT			8
	1					-13		BASE CENTER TUBE	STEEL TUBE Δ		9
	1					-15		BASE CENTER TUBE RING	DOM		10
						-17	1	VERTICAL NYLON TUBE	NATURAL, NYLON		11
						-19	1	TUBE BOTTOM PLUG	WHITE DELRIN/ACETAL		12
						-21	1	SUPPORT INSERT	WHITE DELRIN/ACETAL		13
	X					-23	4	BRACE WELDMENT			14
	1					-25		BRACE TUBE	STEEL TUBE Δ		15
	1					-27		BOTTOM BRACE TAB	A36/1018/1020 HR		16
	1					-29		UPPER BRACE TAB	A36/1018/1020 HR		17
X						-31	1	TUBE TOP RING WELDMENT			18
1						-33		TUBE TOP RING	DOM		19
4						-35		SOCKET HEAD SET SCREW	S.S.	1/4-20 X 1-1/4 (MCMaster-CARR #92313A546) MODIFIED	20
					B/O	-37	5	NYLOCK NUT	S.S.	1/4-20 (MCMaster-CARR #91831A029)	1
					B/O	-39	6	HEX HEAD CAP SCREW	S.S.	3/8-16 X 1 (MCMaster-CARR #92240A624)	1
					B/O	-41	6	SPLIT RING LOCK WASHER	S.S.	Ø3/8 (MCMaster-CARR #92146A031)	1
			1	1		-43		BASE TUBE END CAP	A36/1018/1020 HR		21
					B/O	-45	1	HEX HEAD CAP SCREW	S.S.	1/4-20 X 4-3/4 (MCMaster-CARR #91257A105)	1
					B/O	-47	2	BUTTON HEAD CAP SCREW	S.S.	8-32 X 1/2 (MCMaster-CARR #92949A194)	1
					B/O	-49	2	LANYARD	COATED STEEL	Ø1/16 X 12 (CARR LANE #CL-2-C)	1
			1	1		-51		WHEEL PLATE	A36/1018/1020 HR		22
					B/O	-53	2	3 in. RIGID CASTER		(GALIFCO, COLSON #2.03308.92)	1
					B/O	-55	2	3 in. SWIVEL CASTER W/BRAKE		(GALIFCO, COLSON #2.03356.92 BRK1)	1
					B/O	-57	16	BUTTON HEAD CAP SCREW	S.S.	5/16-18 X 1/2 (MCMaster-CARR #92949A578)	1
					B/O	-59	16	INTERNAL LOCK WASHER	S.S.	Ø5/16 (MCMaster-CARR #91757A111)	1
					B/O	-61	4	REFLECTIVE TAPE	POLYESTER	2 X 9 (MCMaster-CARR #5997T84)	1
					B/O	-65	2	CABLE TAB	ALUMINUM	#10 (CARR-LANE #CL-194-TAB-A)	1
					B/O	-67	2	CABLE TAB	ALUMINUM	Ø1/4 (CARR-LANE #CL-281-TAB-A)	1
					B/O	-69	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	1
					B/O	-71	4	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMaster-CARR #90081A077)	1
					B/O		1	PLACARD	ALUMINUM	RB41011	1
ASSY -31	ASSY -23	ASSY -11	ASSY -3	ASSY -1							



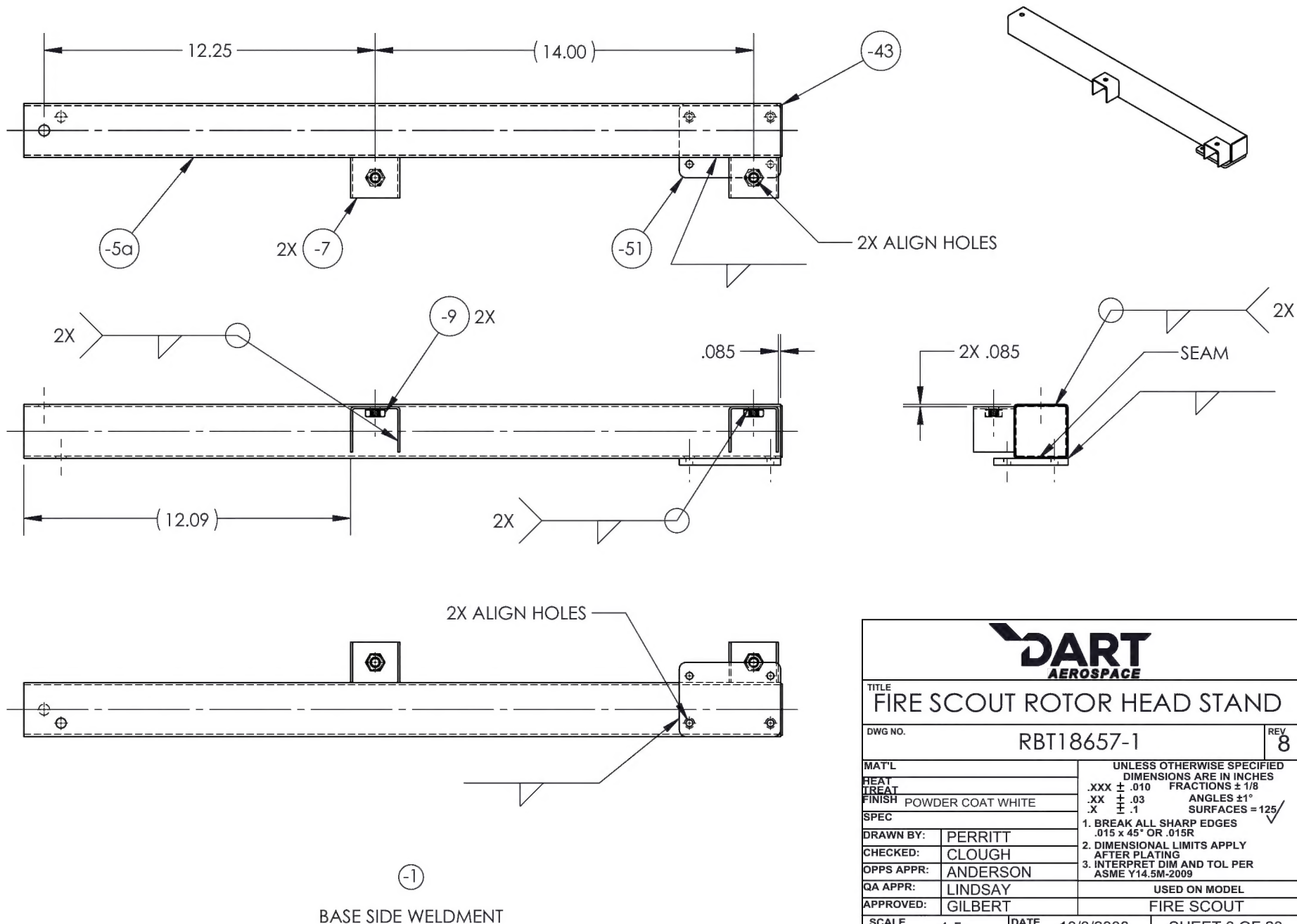
NOTE:

Δ MATERIAL MAY VARY DEPENDING ON COMMERCIAL AVAILABILITY.

DART AEROSPACE																	
TITLE FIRE SCOUT ROTOR HEAD STAND																	
DWG NO. RBT18657	REV 8																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .010 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .03 ANGLES ± 1°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td></td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td></td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .010 FRACTIONS ± 1/8		.XX ± .03 ANGLES ± 1°		.X ± .1 SURFACES = 125/	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
MAT'L	UNLESS OTHERWISE SPECIFIED																
HEAT TREAT	DIMENSIONS ARE IN INCHES																
FINISH	.XXX ± .010 FRACTIONS ± 1/8																
	.XX ± .03 ANGLES ± 1°																
	.X ± .1 SURFACES = 125/																
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																
	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																
DRAWN BY: PERRITT	USED ON MODEL																
CHECKED: CLOUGH	FIRE SCOUT																
OPPS APPR: ANDERSON																	
QA APPR: LINDSAY																	
APPROVED: GILBERT																	
SCALE 1:20	DATE 10/3/2008																
SHEET 2 OF 23																	

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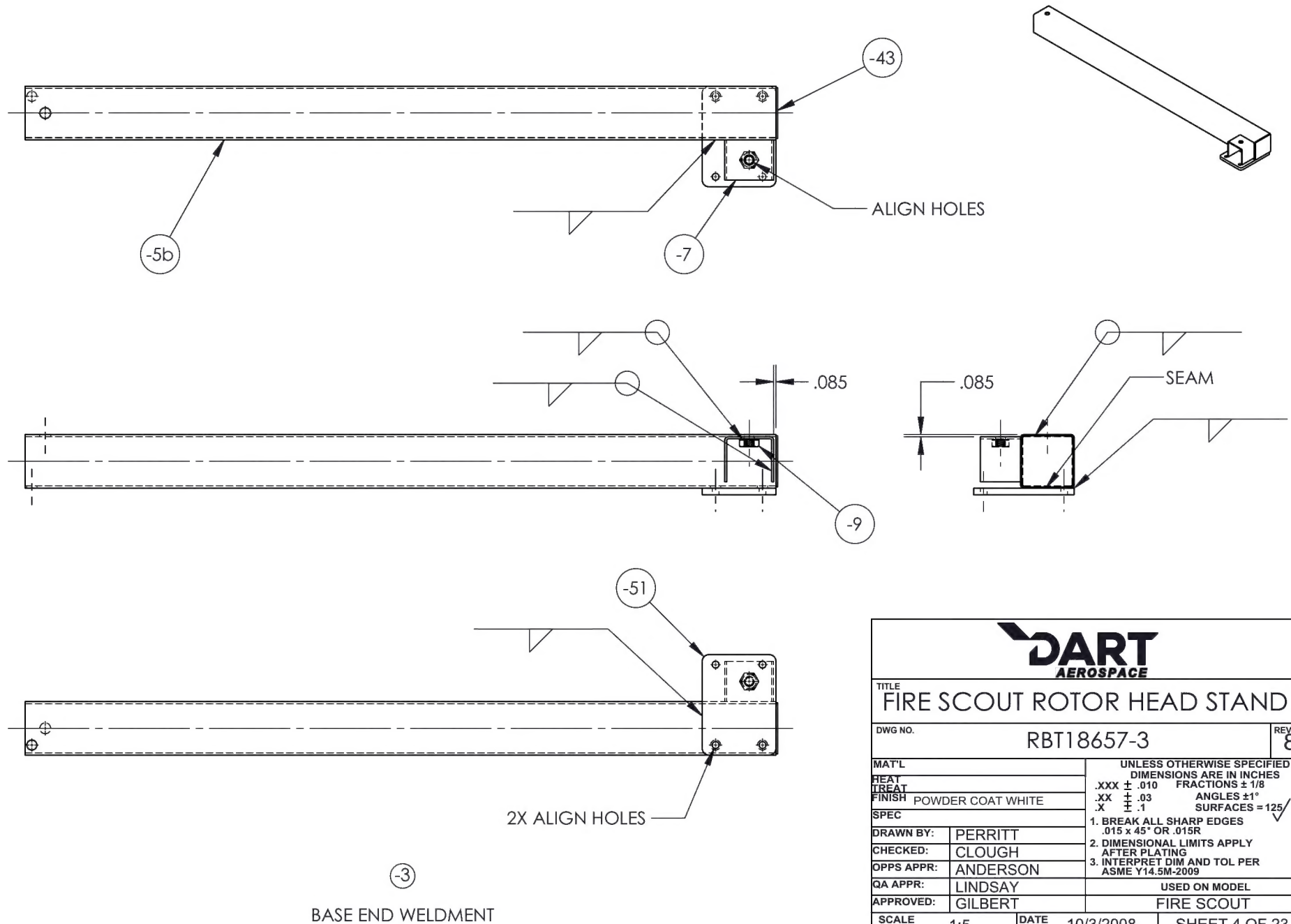
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-1 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-1 CH'D DIM WAS 14.00 IS {14.00}.	10/25/2016	DPD	JAG



DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-1	REV 8
MAT'L HEAT TREAT FINISH POWDER COAT WHITE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:5	DATE 10/3/2008
SHEET 3 OF 23	

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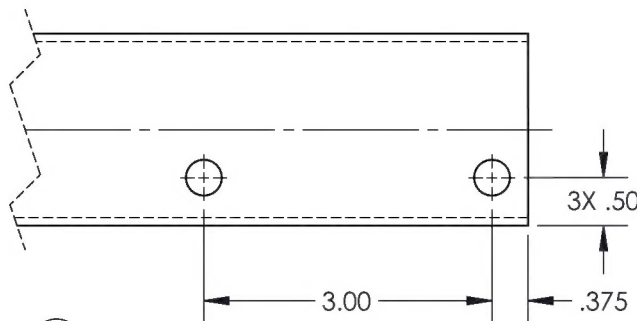
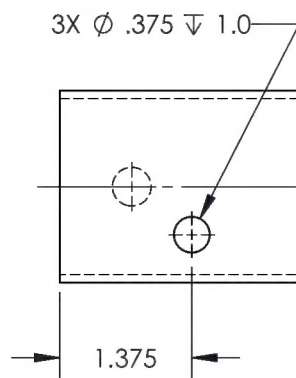
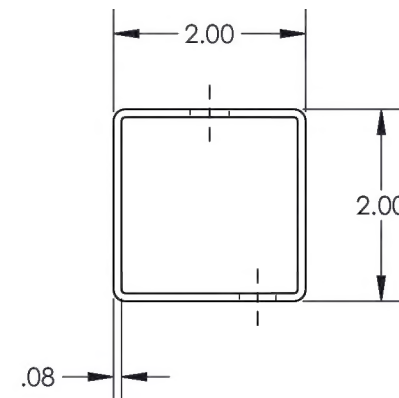
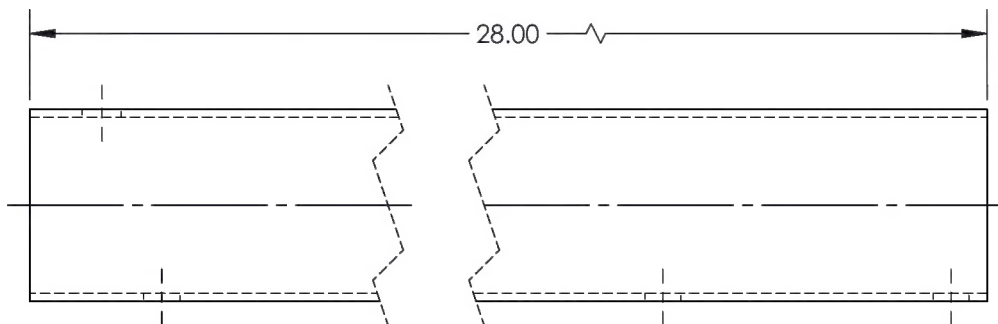
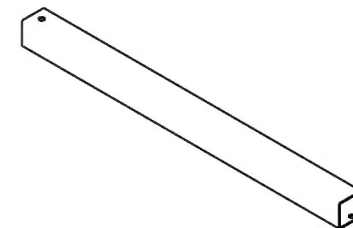
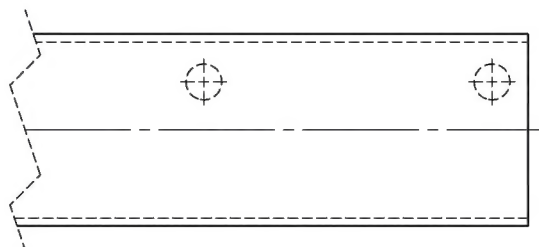
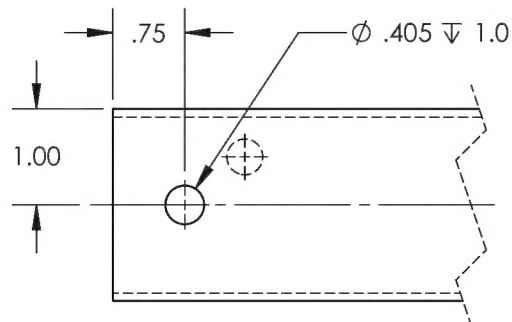
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-3 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.	8/12/2013	RJC	DW



DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-3	REV 8
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL FIRE SCOUT	
SCALE 1:5	DATE 10/3/2008
SHEET 4 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES.	3/2/2009	WP	RW
7		-5a DELETED NOTE WAS SEAM ON BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-5a CH'D DIMS WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08, WAS Ø.405 ONE WALL IS Ø.405 ∇ 1.0, WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ∇ 1.0.	10/25/2016	DPD	JAG



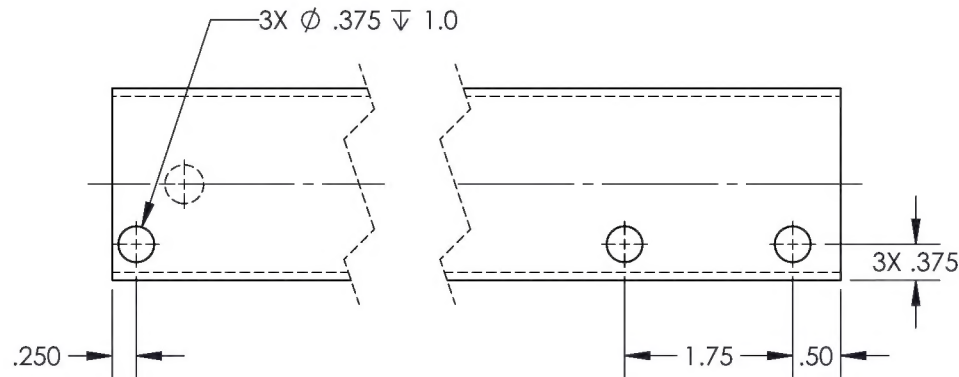
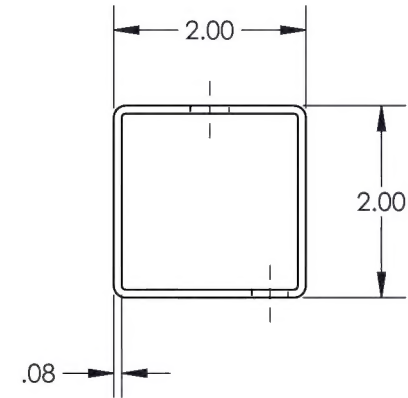
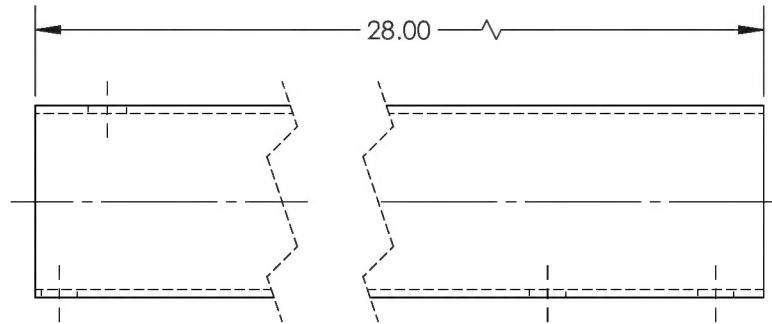
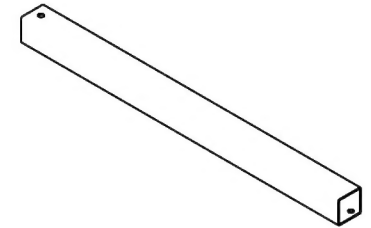
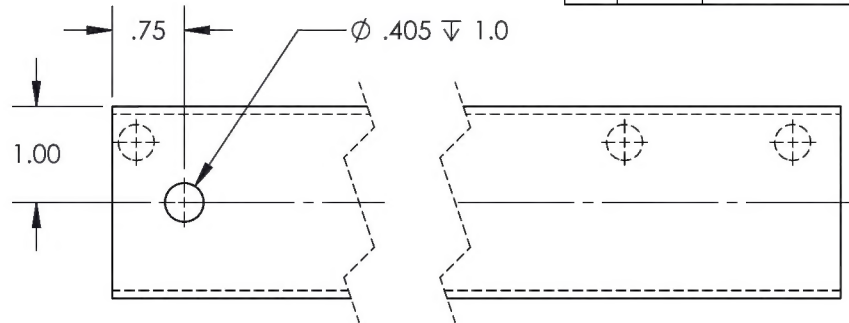
(-5a)

BASE SIDE TUBE

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-5a	REV 8
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 SPEC DRAWN BY: PERRITT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .010 FRACTIONS \pm 1/8 .XX \pm .03 ANGLES \pm 1° .X \pm .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL FIRE SCOUT	
SCALE 1:2	DATE 10/3/2008
SHEET 5 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		SEPARATED -5 INTO -5a & -5b BECAUSE OF CLEARANCE HOLES.	3/2/2009	WP	RW
7		-5b DELETED NOTE WAS SEAM ON BOTTOM.	8/12/2013	RJC	DW
8		-5b CH'D DIMS WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08, WAS Ø.405 ONE WALL IS Ø.405 ± 1.0, WAS Ø.375 (x3) ONE WALL IS 3X Ø.375 ± 1.0.	10/25/2016	DPD	JAG

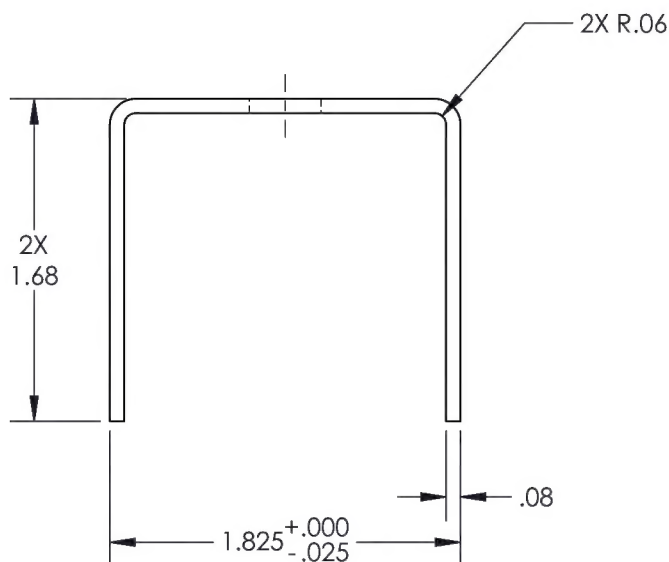
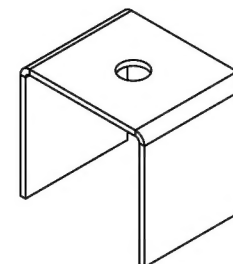
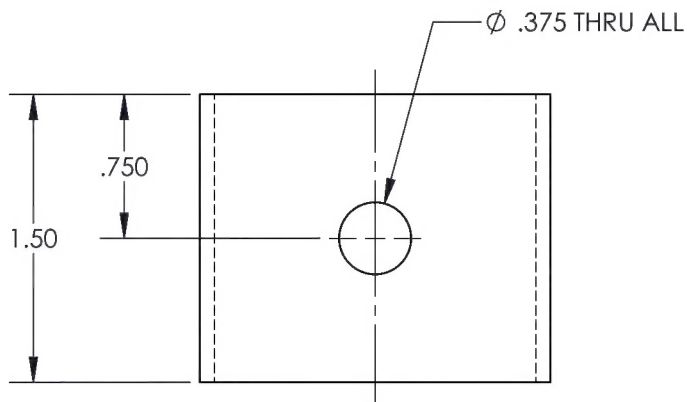


(-5b)
BASE TUBE

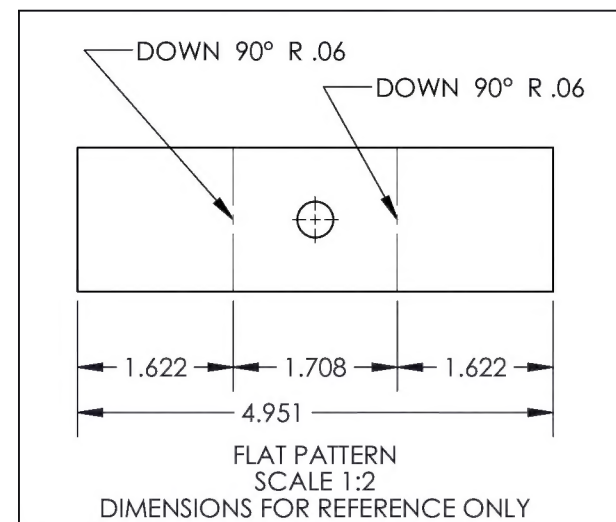
DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-5b	REV 8
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -3	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 10/3/2008
	SHEET 6 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		CH'D P/N -7 OVERALL LENGTH FROM 4.872 & DIM TO FIRST FOLD LINE TO 1.606 PER W.P.	10/27/2009	WP	RW
6		CH'D -7 DIMENSION FROM 1.825 +.000-.020 TO 1.825 +.000-.025, CH'D 1.500 TO 1.50, CH'D 1.680 TO 1.68 AND ADDED NOTE 1 PER S.E.	6/4/2012	RJC	SE
8	16-0189	-7 CH'D DIMS WAS 1.68 IS 2X 1.68, WAS .075 IS .08. CH'D MAT'L WAS A709 GRADE 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



(-7)
CLIP



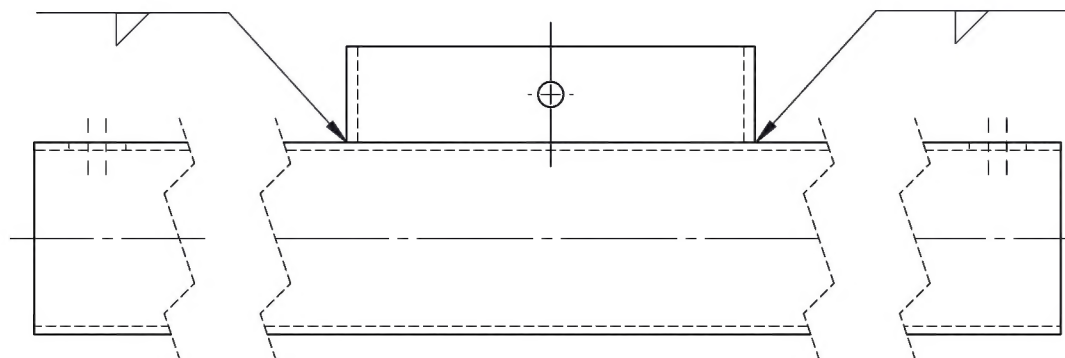
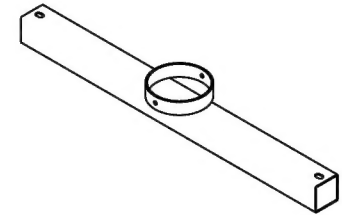
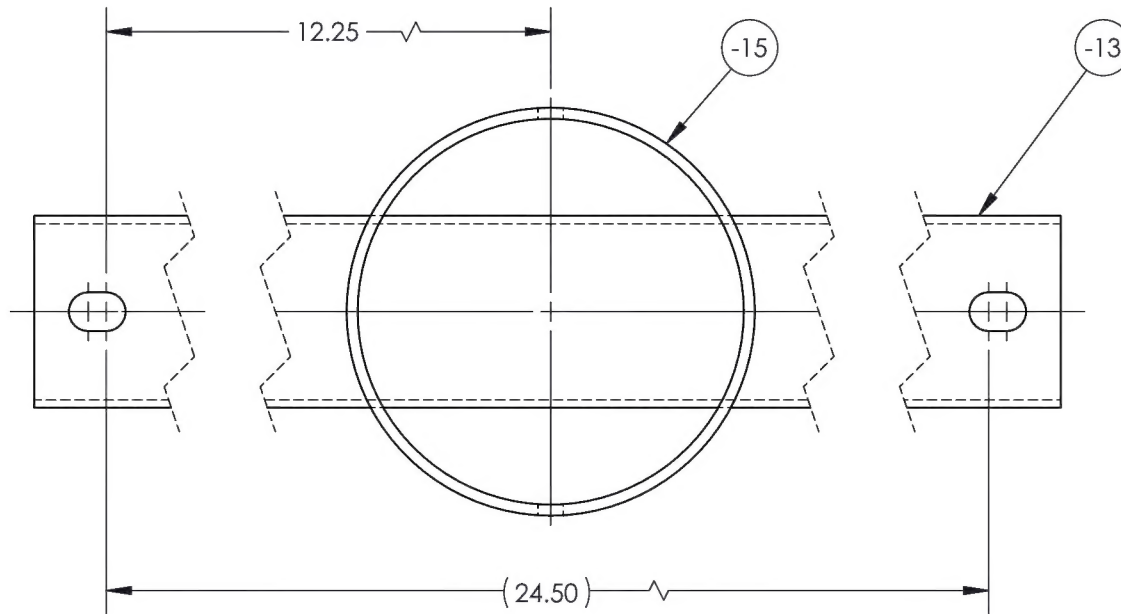
TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. RBT18657-7 REV 8

MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1 & -3		.XXX ± .010	FRACTIONS ± 1/8
SPEC		.XX ± .03	ANGLES ± 1°
DRAWN BY: PERRITT		.X ± .1	SURFACES = 125✓
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:1	DATE 10/3/2008	USED ON MODEL	
		FIRE SCOUT	
		SHEET 7 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-11 CH'D DIM WAS 24.50 IS (24.50).	10/25/2016	DPD	JAG



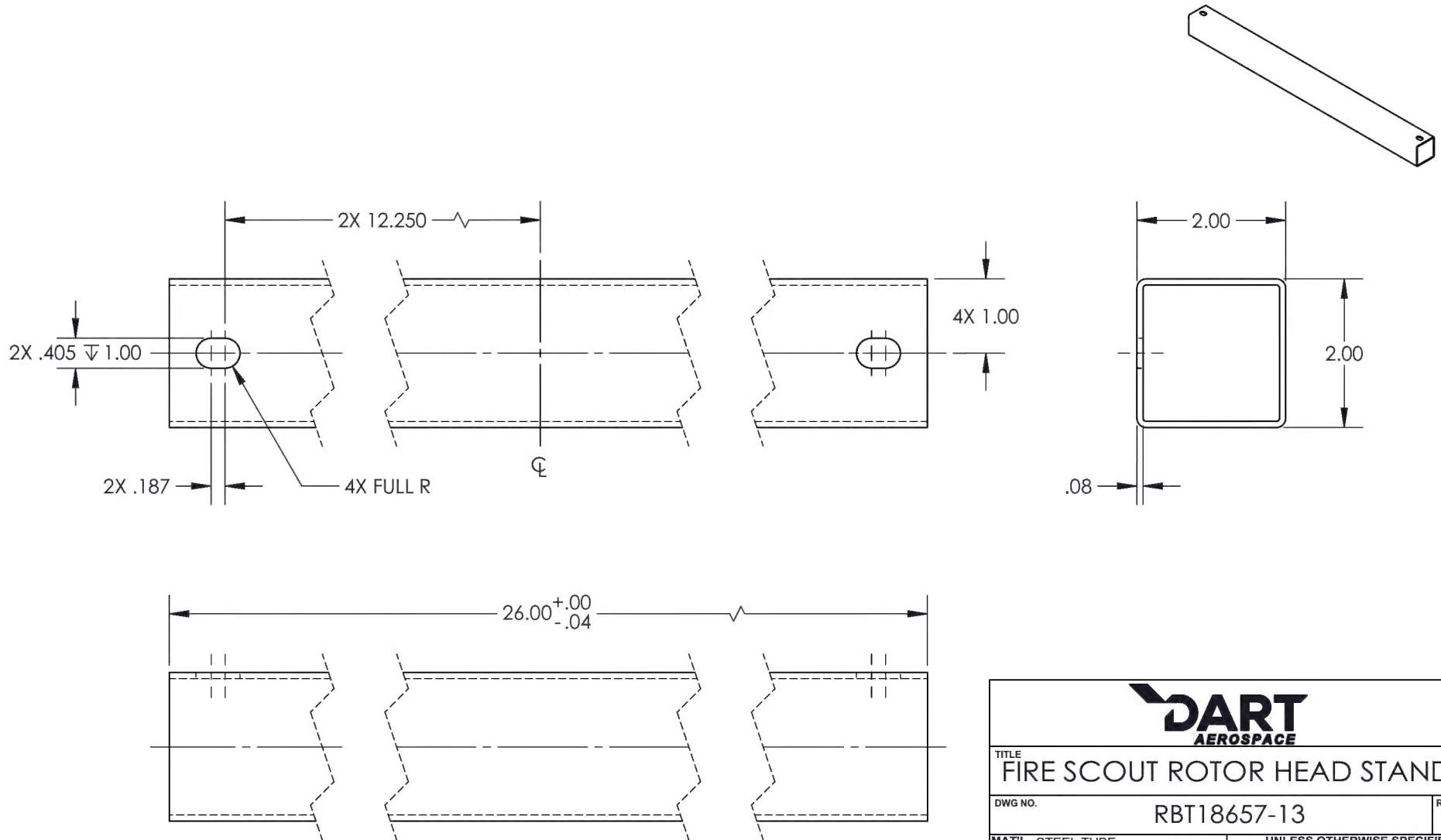
(-11)

BASE CENTER TUBE WELDMENT

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-11	REV 8
MAT'L AL 7075-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT POWDER COAT WHITE	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT WHITE	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 8 OF 23	

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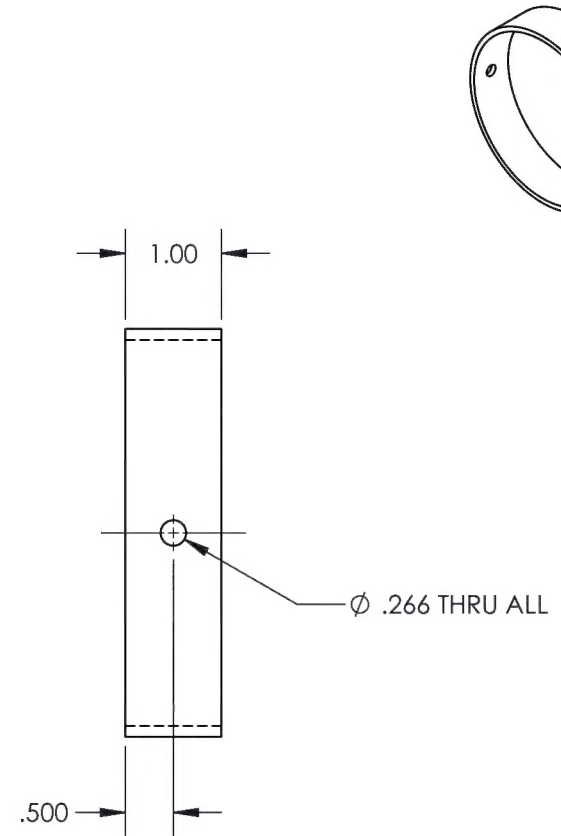
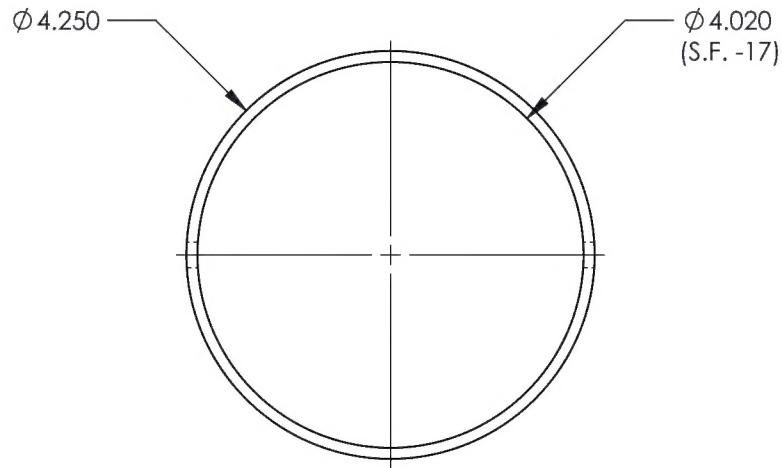
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		CH'D Ø.405 HOLE TO A SLOT ON BOTH ENDS -13 PER G.E.	3/3/2011	RJC	GE
8	16-0189	-13 CH'D DIM WAS 1.00 (x2) IS 4X 1.00, WAS (2.00) IS 2.00, WAS (2.00) IS 2.00, WAS (.083) WALL IS .08.	10/25/2016	DPD	JAG



DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-13	REV 8
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -11 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	USED ON MODEL
CHECKED: CLOUGH	FIRE SCOUT
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 10/3/2008
SHEET 9 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8		-15 CH'D DIM WAS Ø4.00 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17).	10/25/2016	DPD	JAG



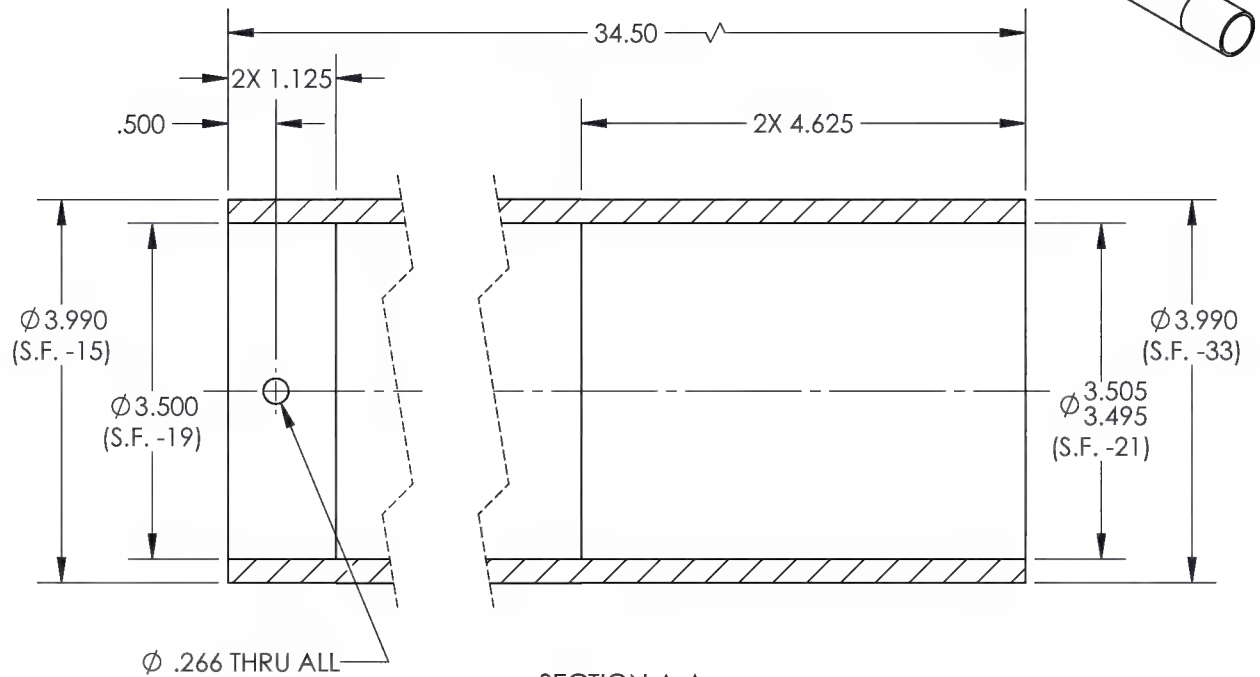
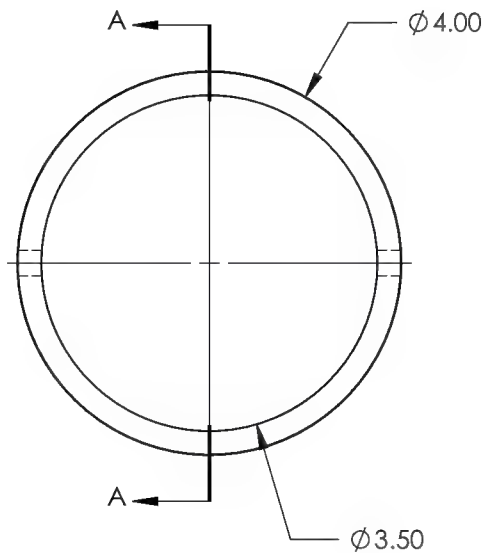
(-15)

BASE CENTER TUBE RING

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-15	REV 8
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -11	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 10/3/2008
	SHEET 10 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADJUSTED -17 TO ALLOW FOR OVERSIZE PLASTIC TUBE CONDITIONS.	11/24/2008	WP	RW
8	16-0189	-17 CH'D DIM WAS Ø3.500 S.F. -21 IS Ø3.495-3.505 (S.F. -21). ADDED DIMS Ø3.50, Ø4.00. CH'D MAT'L FROM NATURAL TO NATURAL, NYLON.	10/25/2016	DPD	JAG



SECTION A-A

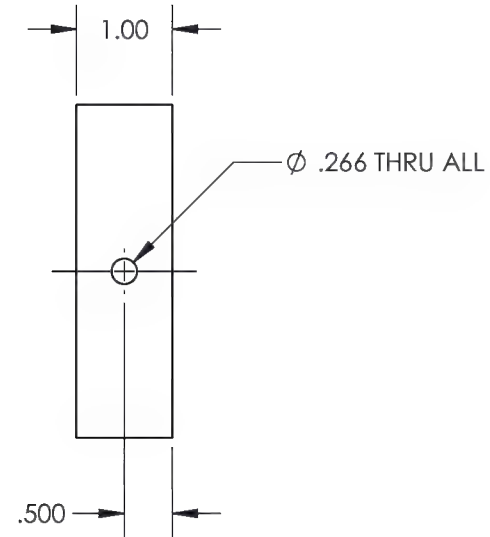
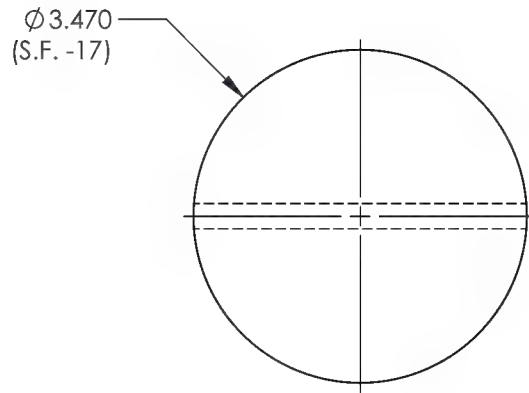
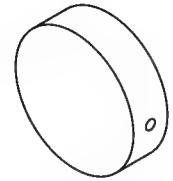
(-17)

VERTICAL NYLON TUBE

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-17	REV 8
MAT'L NATURAL, NYLON	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 11 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-19 CH'D DIM WAS Ø3.500 S.F. -17 IS Ø3.470 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL.	10/25/2016	DPD	JAG



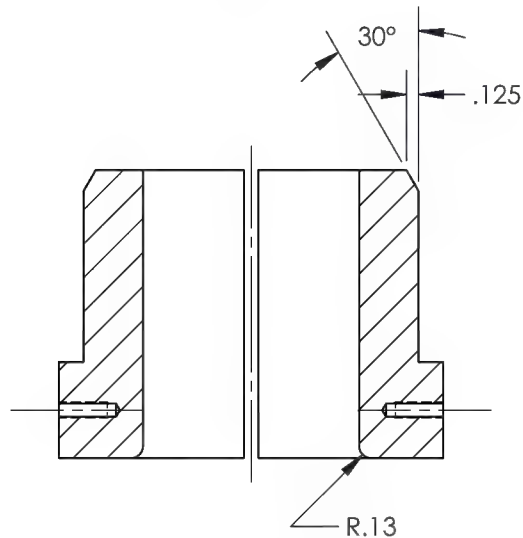
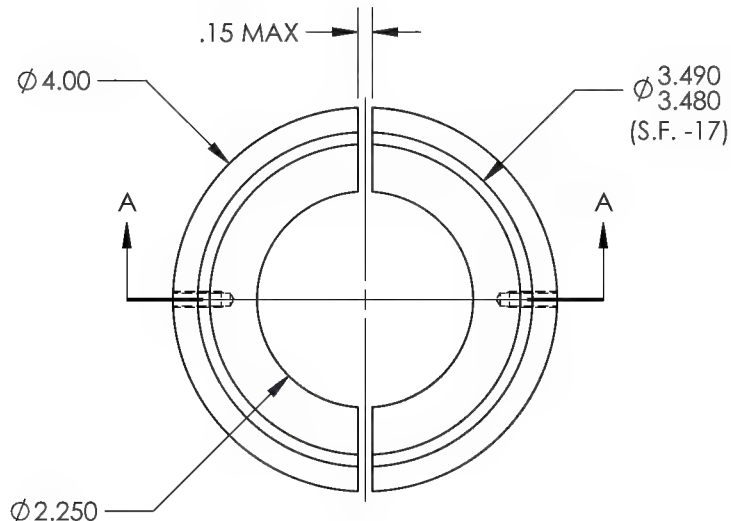
(-19)

TUBE BOTTOM PLUG

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-19	REV 8
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED
REAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
SCALE 1:2	ASME Y14.5M-2009
DATE 10/3/2008	USED ON MODEL
SHEET 12 OF 23	FIRE SCOUT

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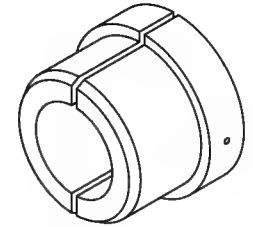
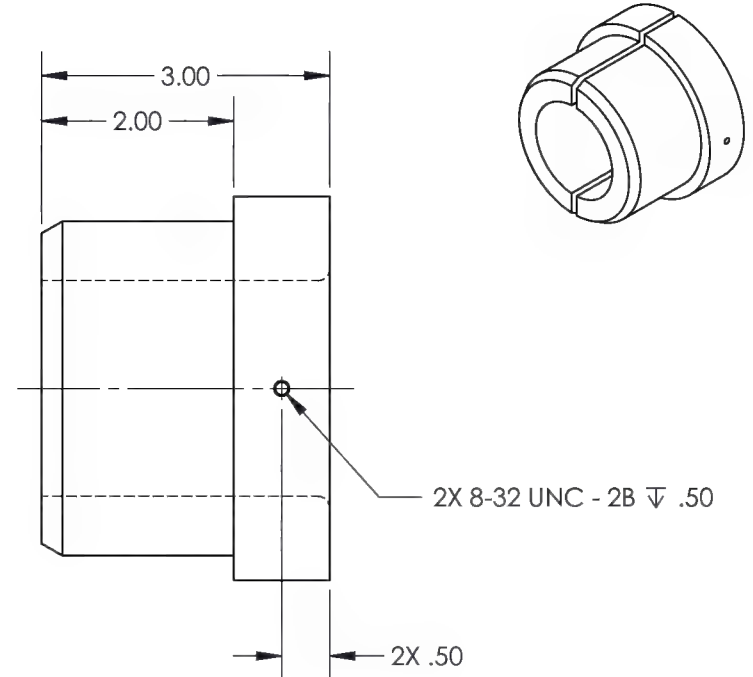
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-21 CH'D DIM WAS Ø3.490 IS Ø3.480-3.490 (S.F. -17). CH'D MAT'L WAS DELRIN IS WHITE DELRIN/ACETAL.	10/25/2016	DPD	JAG



SECTION A-A

(-21)

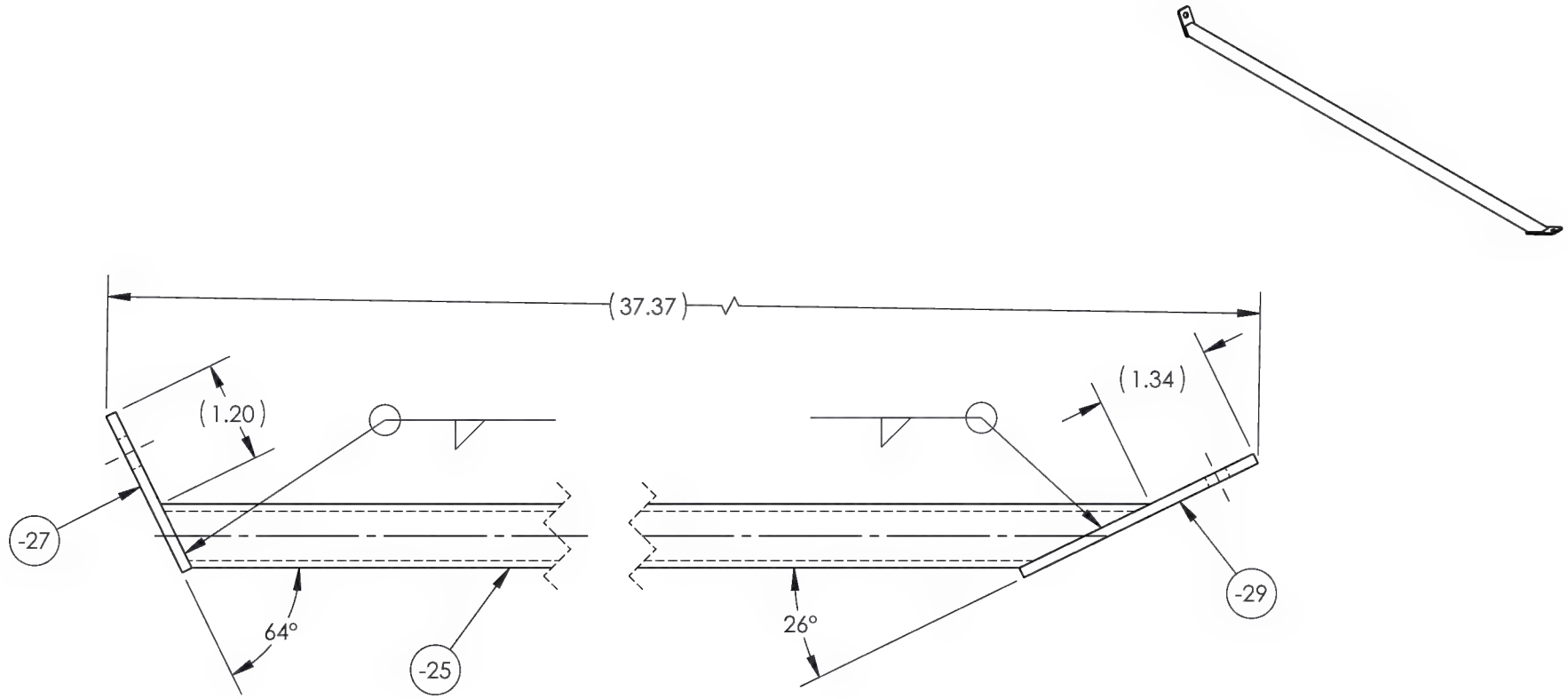
SUPPORT INSERT



DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-21	REV 8
MAT'L WHITE DELRIN/ACETAL	UNLESS OTHERWISE SPECIFIED
REAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 13 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-23 DELETED NOTE 1 WAS ASSEMBLE WITH ALL TUBE SEAMS ON THE BOTTOM.	8/12/2013	RJC	DW
8	16-0189	-23 CH'D DIM WAS {37.34} IS {37.37}. ADDED WELD SYMBOLS.	10/25/2016	DPD	JAG

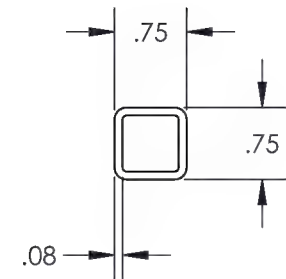
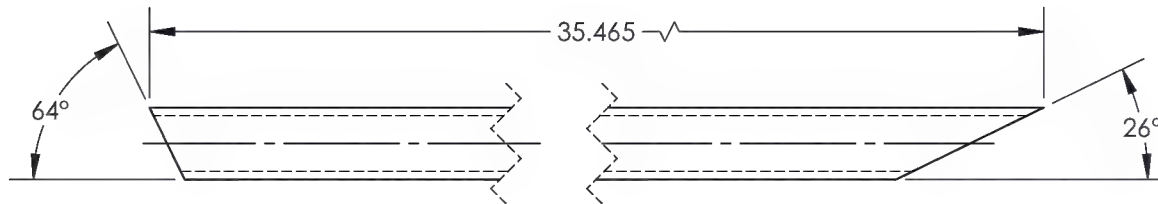
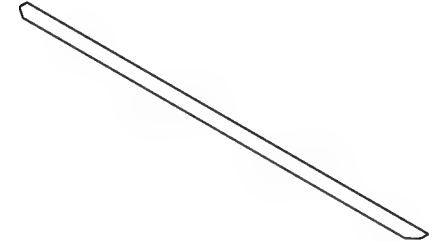


(-23)
BRACE WELDMENT

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-23	REV 8
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT POWDER COAT WHITE	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT WHITE	.XX ± .03 ANGLES ± 1°
SPEC PERRITT	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 14 OF 23	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-25 CH'D DIMS WAS (.75) IS .75, WAS (.75) IS .75, WAS (.083) WALL IS .08. CH'D MAT'L WAS 1018 SQ. TUBE IS STEEL TUBE.	10/25/2016	DPD	JAG

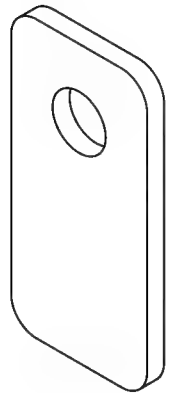
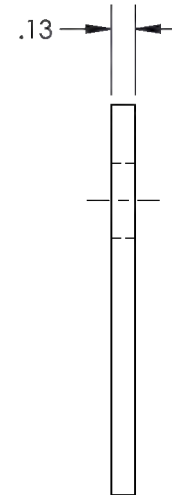
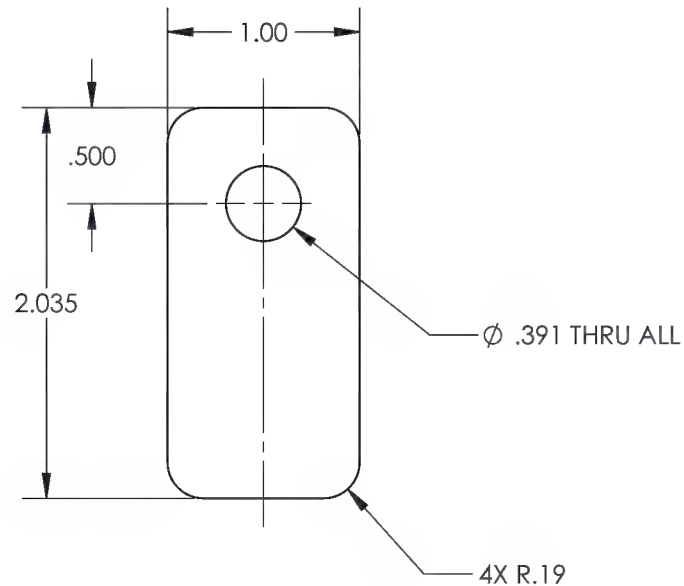


(-25)
BRACE TUBE

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-25	REV 8
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 10/3/2008
	SHEET 15 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-27 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



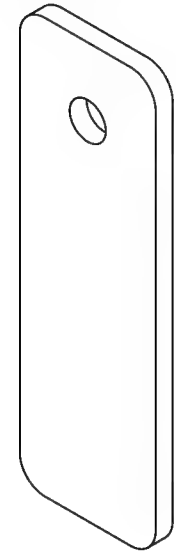
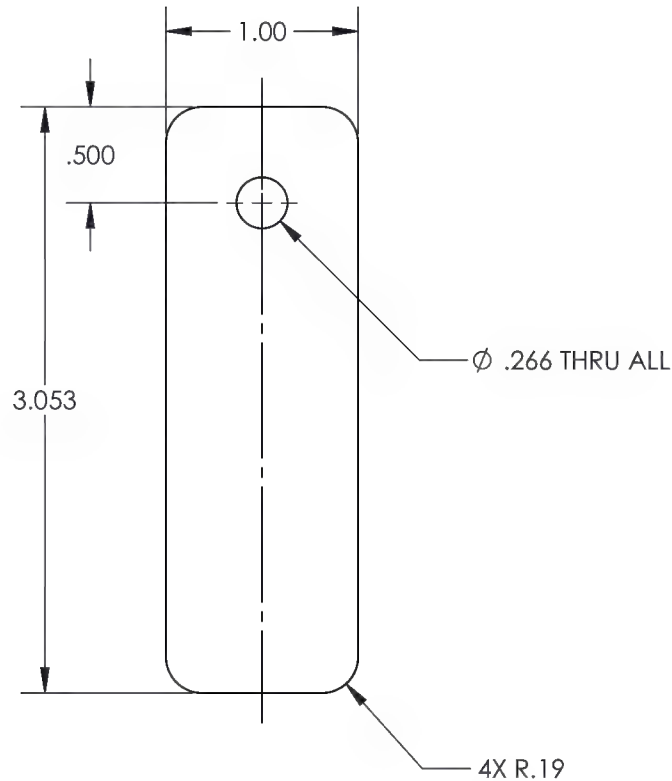
(-27)

BOTTOM BRACE TAB

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-27	REV 8
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 10/3/2008
	SHEET 16 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-29 CH'D DIM WAS (.125) IS .13. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



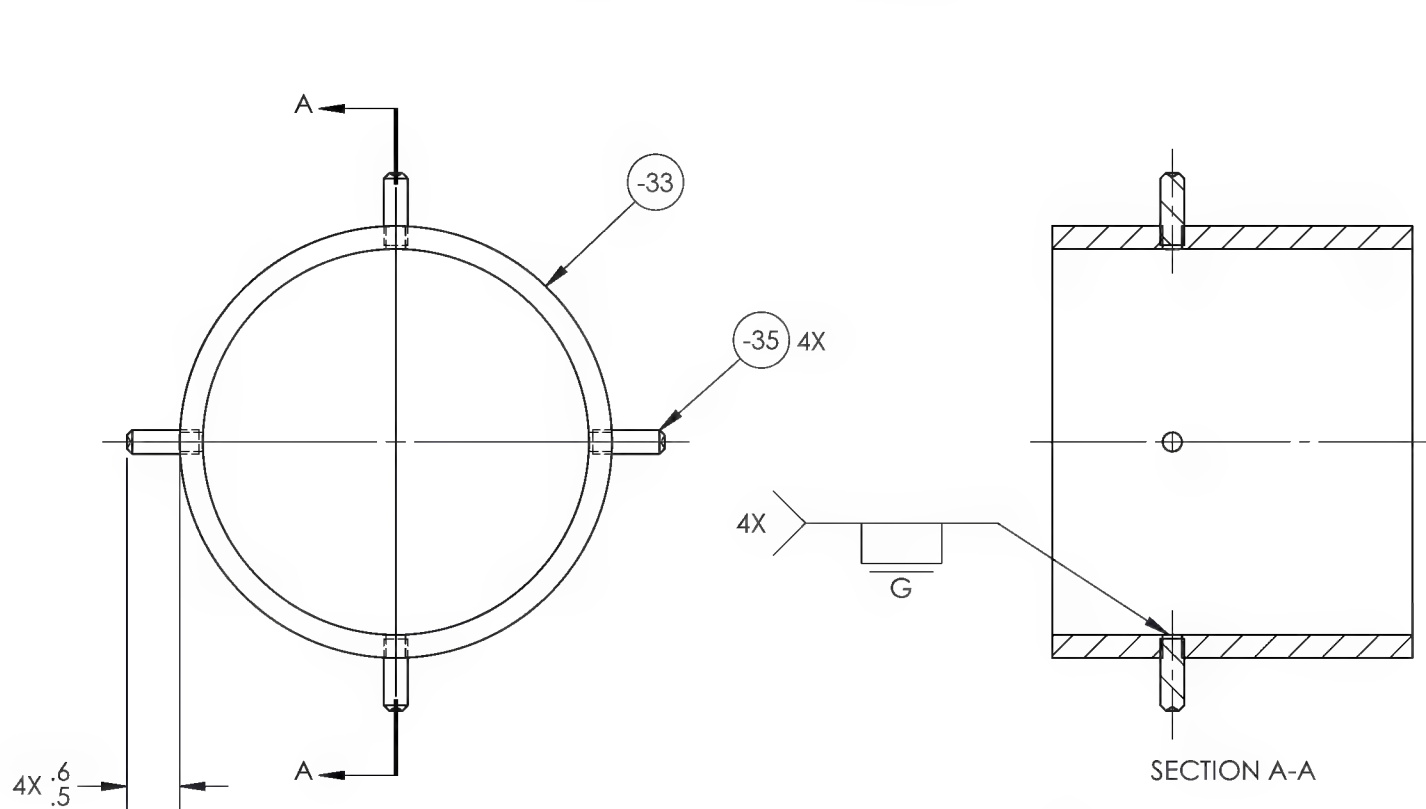
(29)

UPPER BRACE TAB

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-29	REV 8
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 10/3/2008
	SHEET 17 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-31 ADDED .5 MIN .6 MAX DIM.	8/12/2013	RJC	DW
8	16-0189	-31 ADDED NO POWDER COAT ON THREADS NOTE.	10/25/2016	DPD	JAG



NOTE:
NO POWDER COAT ON THREADS.

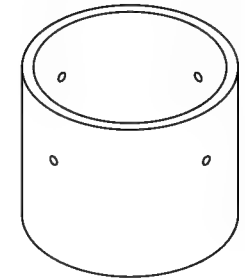
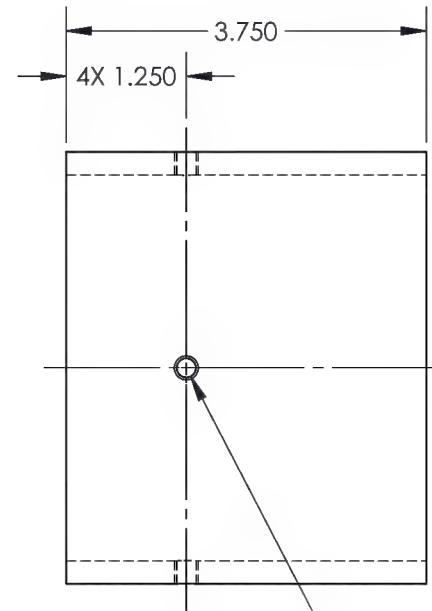
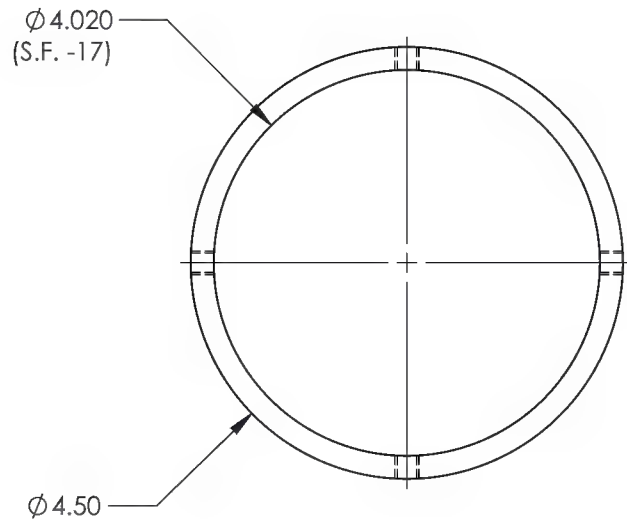
DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-31	REV 8
MAT'L FIRE TREAT FINISH POWDER COAT WHITE SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:2	DATE 10/3/2008
SHEET 18 OF 23	

(31)

TUBE TOP RING WELDMENT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		CH'D LENGTH -33 FROM 4.250 TO 3.750 PER D.W.	1/15/2010	RJC	RW
8	16-0189	-33 CH'D DIM WAS Ø4.000 S.F. -17 AFTER POWDER COATING IS Ø4.020 (S.F. -17).	10/25/2016	DPD	JAG



4X 1/4-20 UNC ∇ 2.3

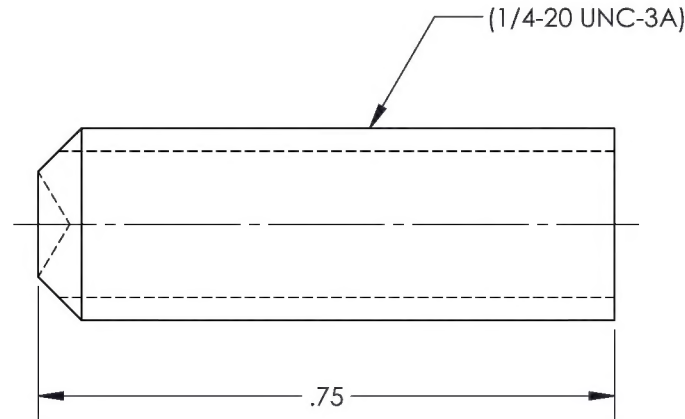
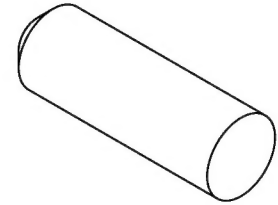
(-33)

TUBE TOP RING

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-33	REV 8
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -31	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 10/3/2008
	SHEET 19 OF 23

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		-35 CH'D FROM STEEL TO STAINLESS & ADDED DWG TO MODIFY AND NOTE.	8/12/2013	RJC	DW



NOTE:
CUT TO LENGTH FROM SOCKET END.



TITLE
FIRE SCOUT ROTOR HEAD STAND

DWG NO. RBT18657-35 REV 8

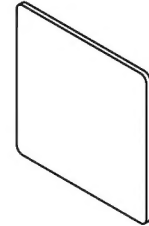
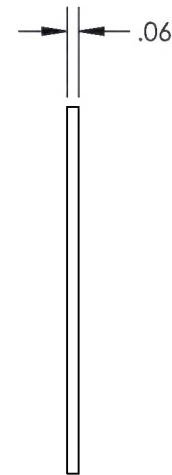
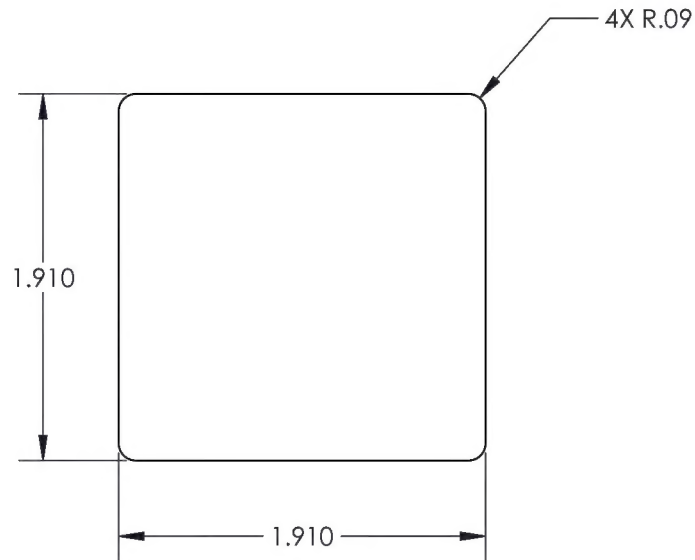
MAT'L S.S.		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: PERRITT		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 4:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 10/3/2008		USED ON MODEL	
SHEET 20 OF 23		FIRE SCOUT	

(-35)

SOCKET HEAD SET SCREW

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-43 CH'D DIM WAS 16ga. (.060) IS .06. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



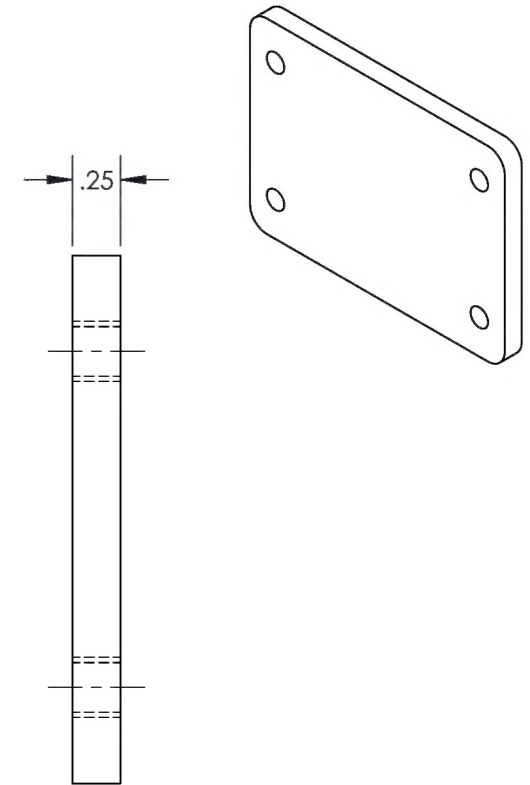
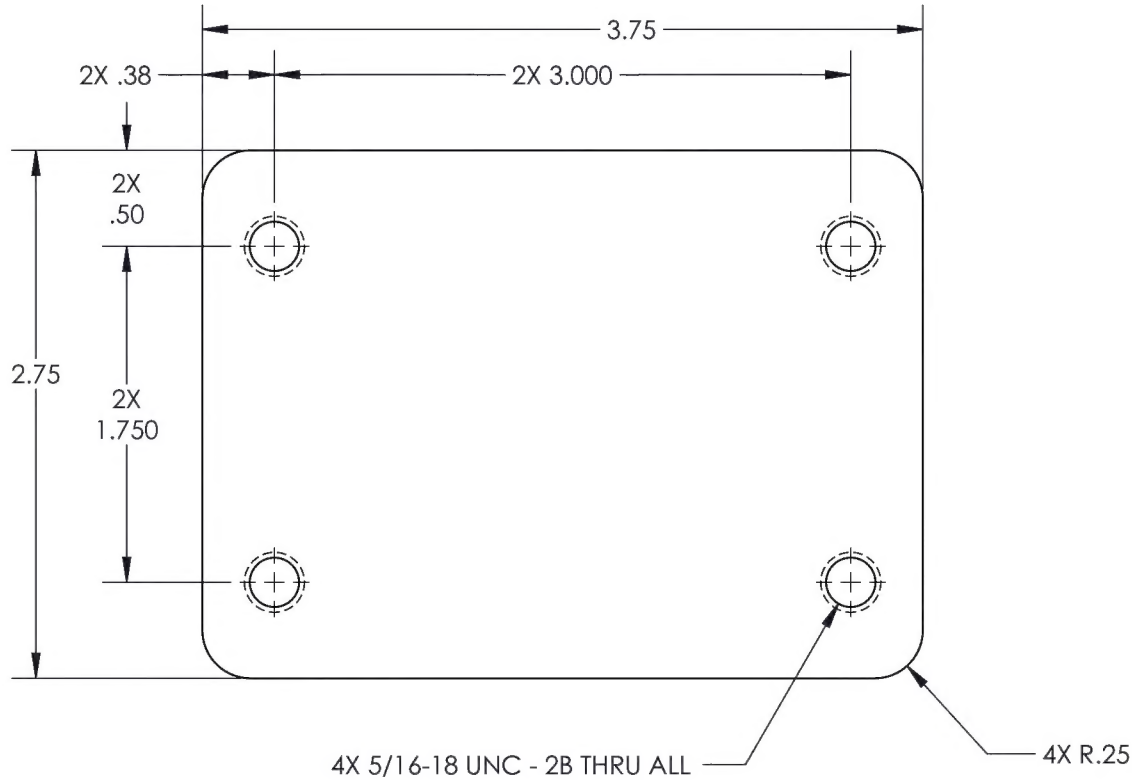
(-43)

BASE TUBE END CAP

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-43	REV 8
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 & -3	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 10/3/2008
	SHEET 21 OF 23

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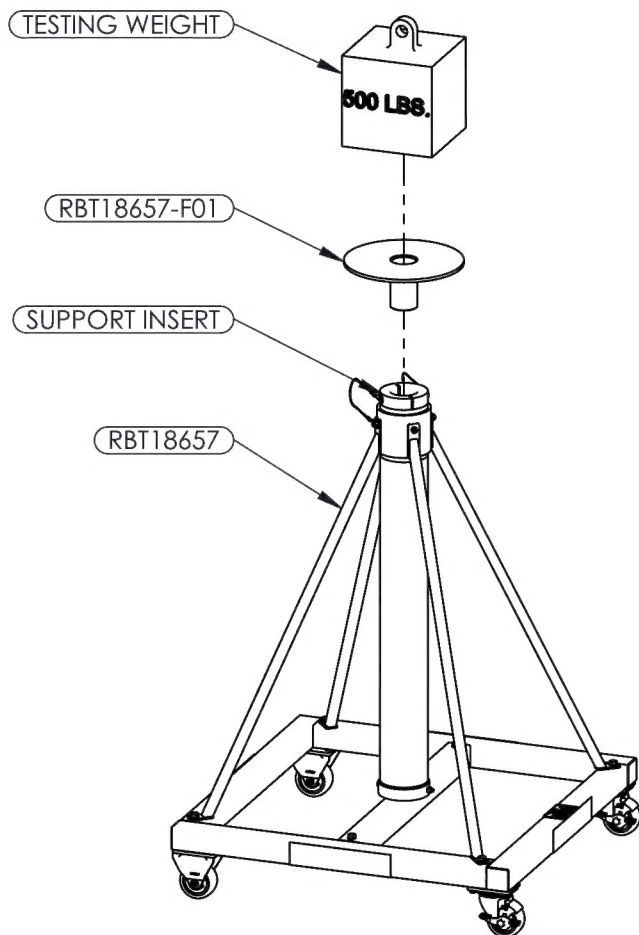
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
8	16-0189	-51 CH'D DIMS WAS (.25) IS .25, WAS .375 IS 2X .38, WAS 3.000 IS 2X 3.000, WAS .50 IS 2X .50, WAS 1.750 IS 2X 1.750. CH'D MAT'L WAS A709 GRD 36 IS A36/1018/1020 HR.	10/25/2016	DPD	JAG



(51)
WHEEL PLATE

DART AEROSPACE	
TITLE FIRE SCOUT ROTOR HEAD STAND	
DWG NO. RBT18657-51	REV 8
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 & -3	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	FIRE SCOUT
SCALE 1:1	DATE 10/3/2008
SHEET 22 OF 23	

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INSPECTOR: _____

TESTER: _____

S.N.: _____

DATE: _____

INSPECTION & TESTING PROCEDURES FOR THE RBT18675 ROTOR HEAD STAND ASSEMBLY. THE RBT18657 IS DESIGNED FOR HOLDING THE FIRE SCOUT ROTOR HEAD DURING MAINTENANCE PROCEDURES. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE AND AFTER EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

91 DAY INSPECTION:

1. CLEAN ENTIRE UNIT AND REMOVE CORROSION.
2. CHECK THE ENTIRE UNIT FOR DAMAGE, CRACKS, AND DISORTIONS.
3. CHECK ALL BOLTS FOR TIGHTNESS AND DAMAGE. TIGHTEN OR REPLACE IF NECESSARY.
4. CHECK THE SUPPORT INSERT ASSEMBLY FOR CRACKS AND DAMAGE.
5. CHECK ALL WELDS FOR CRACKING AND DISTORTION.
6. CHECK ALL WHEELS FOR CRACKS AND SMOOTHNESS OF OPERATION.
7. LUBRICATE WHEELS WITH MIL-L-7870 GENERAL PURPOSE OIL. REPAINT IF NECESSARY.

IF ANY DAMAGE IS FOUND, REPAIR OR REPLACE THE UNIT.

3 YEAR WEIGHT TESTING:

1. PLACE THE RBT18657-F01 TESTING FIXTURE INTO THE SUPPORT INSERT.
2. PLACE A 500 LB. TESTING WEIGHT ON TOP OF THE TESTING FIXTURE FOR 5 MINUTES WHITE EXAMINING THE ROTOR HEAD STAND FOR CRACKS OR DISTORIONS.
3. AFTER 5 MINUTES REMOVE THE TESTING WEIGHT AND FIXTURE.
4. RE-INSPECT ENTIRE ASSEMBLY.

SWL: 250 LBS.

DART
AEROSPACE

190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE			
FIRE SCOUT ROTOR HEAD STAND			
DWG NO.	RBT18657	REV	8
SCALE	1:16	DATE	10/3/2008
CUSTOMER 1 OF 1		SHEET	23 OF 23